

Date: Thursday, 9/20/2007 3:29:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	34751	Part Number	D2574
Estimate Number	10534	Drawing Number	D2574 REV E
P.O. Number	N/A	Project Number	N/A
This Issue	9/20/2007	Drawing Revision	E
Prsht Rev.	NC	Material	N/A
First Issue	M/R	Due Date	10/1/2007
Previous Run	34370	Qty:	12 Um: Each
Written By	JL		
Checked & Approved By	SP 07.09.20		
Comment	Est Rev 4 As Per Rev E 06-01-27 JLM		

## Additional Product

Job Number:



Seq.#:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B31388  JL 07/10/02 12
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: 34751 Double check by: JL  1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. JL / EC 07.10.10 (12)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 JL / EC 07.10.10 (12)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL / EC 07.10.10 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: AD Date: 07/10/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:29:14 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 34751

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

9/20 07/10/15

(12)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(12x)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.L

07/10/15

7.0 POWDER COATING POWDER COATING



M105088

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SL

09-10-16

(12)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



GJ 09/10/16 (12)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

GJ 09/10/16 (12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DA 07/10/17

(12)

Job Completion



07/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34751
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

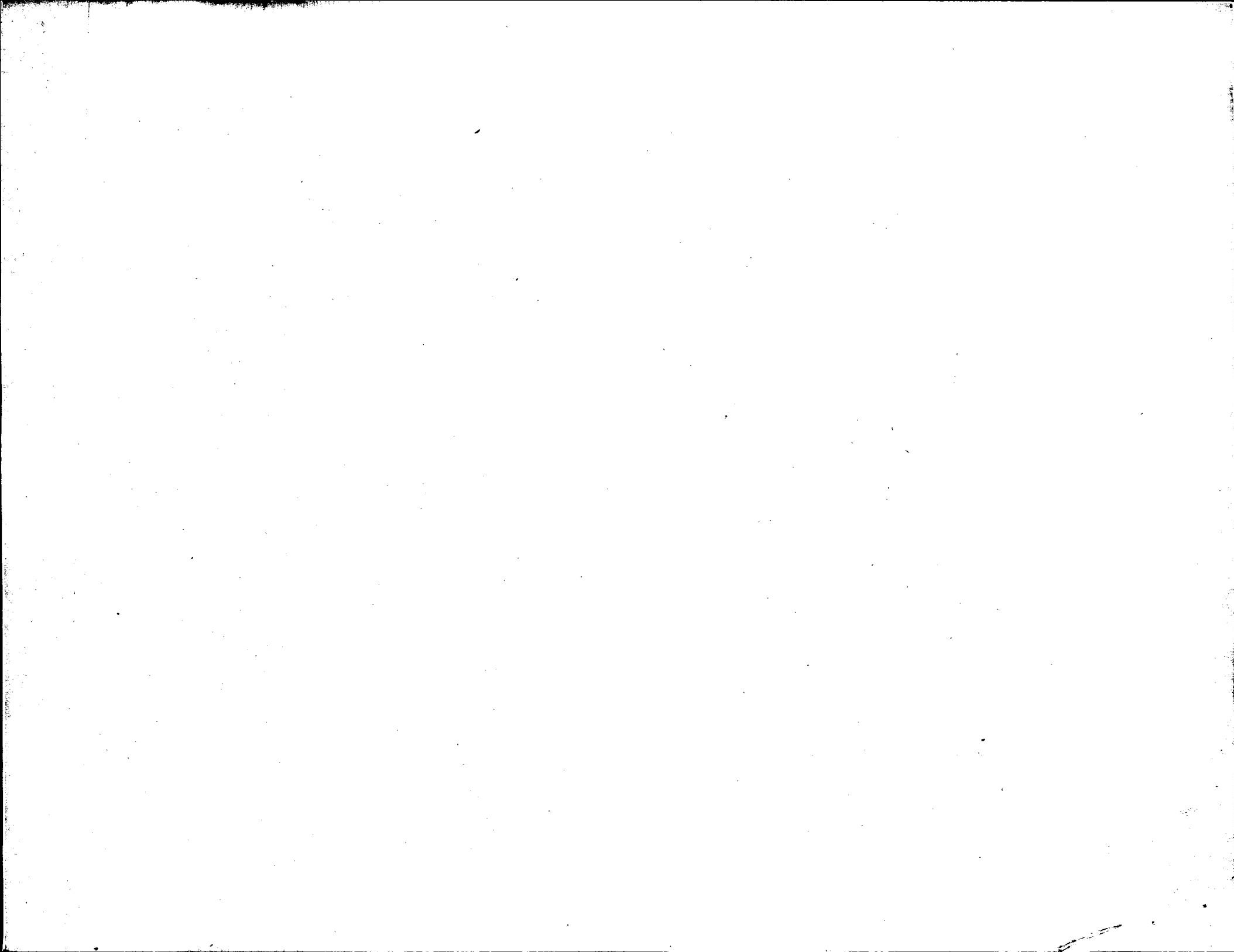
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.506	3.500	3.498	3.497		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.999	8.007	8.004		
F	0.490	0.510		0.501	.503	.502	.500		
G	0.257	0.262	DT8683	0.259	0.258	0.258	.254		
H	0.375	0.380	DT8684	0.377	0.377	0.376	.377		
I	0.490	0.510		0.502	0.501	0.502	.502		
J	1.174	1.184		1.179	1.179	1.178	1.181		
K	0.558	0.578		0.570	0.570	0.570	.570		
L	1.174	1.184		1.179	1.179	1.178	1.181		
M	1.365	1.375		1.369	1.369	1.368	1.365		
N	2.495	2.505		2.499	2.499	2.499	2.500		
O	4.119	4.129		4.121	4.121	4.122	4.125		
P	0.115	0.135		0.124	0.124	0.124	.125		
Q	0.115	0.135		0.135	0.135	0.135	.135		
R	0.240	0.260		0.249	0.248	0.249	.250		
S	0.115	0.135		0.129	0.129	0.128	.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.228	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.236	0.237	.237		
W	0.115	0.135		0.129	.127	.127	.127		
X	0.307	0.312		0.311	.311	.311	.311		
Y	0.760	0.765		0.760	.760	.764	.764		
Z	0.352	0.372		0.366	.366	.370	.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	.626	.624	.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.247	.247		
AE	1.500	1.520		1.509	1.510	1.510	1.512		
AF	0.115	0.135		0.135	0.135	0.135	.136		
AG	0.240	0.280		0.265	0.275	0.270	.270		
AH	0.240	0.260		0.249	0.247	0.248	.246		
AI	2.000	2.020		2.000	2.001	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: JL / J.L.  
Date: 02.10.14

Audited by: Amj  
Date: 07.10.15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>JL</u> <u>JL</u>



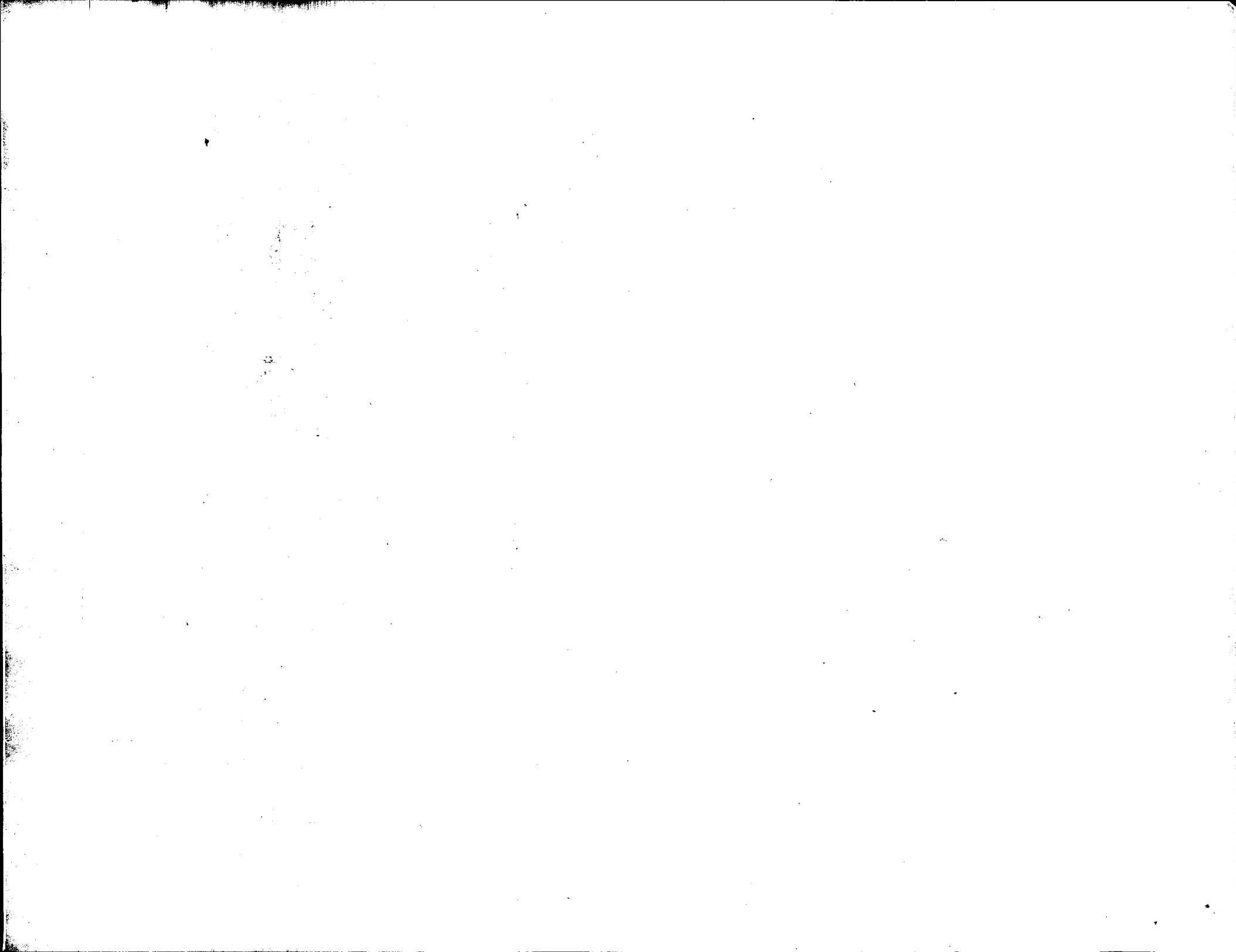
DART AEROSPACE LTD	Work Order:	34751
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5*	62	78	84	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.005		
F	0.490	0.510		.508	.508	.508	.508		
G	0.257	0.262	DT8683	.259	.259	.259	.259		
H	0.375	0.380	DT8684	.377	.377	.377	.377		
I	0.490	0.510		.506	.501	.505	.505		
J	1.174	1.184		1.183	1.183	1.183	1.181		
K	0.558	0.578		.576	.572	.572	.572		
L	1.174	1.184		1.182	1.183	1.183	1.181		
M	1.365	1.375		1.371	1.371	1.372	1.371		
N	2.495	2.505		2.500	2.501	2.500	2.499		
O	4.119	4.129		4.121	4.124	4.124	4.123		
P	0.115	0.135		.124	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.251	.251	.251		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.234	3.234	3.231		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.120	.122	.122	.122		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.369	.369	.369	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.620	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.511	1.511	1.510	1.511"		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043		.040	.040	.040	.040		
Accept/Reject									

Measured by:	S.F	Audited by:	<i>JM</i>
Date:	07/10/15	Date:	07/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JM</i>	<i>JM</i>



DART AEROSPACE LTD	Work Order:	34751
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

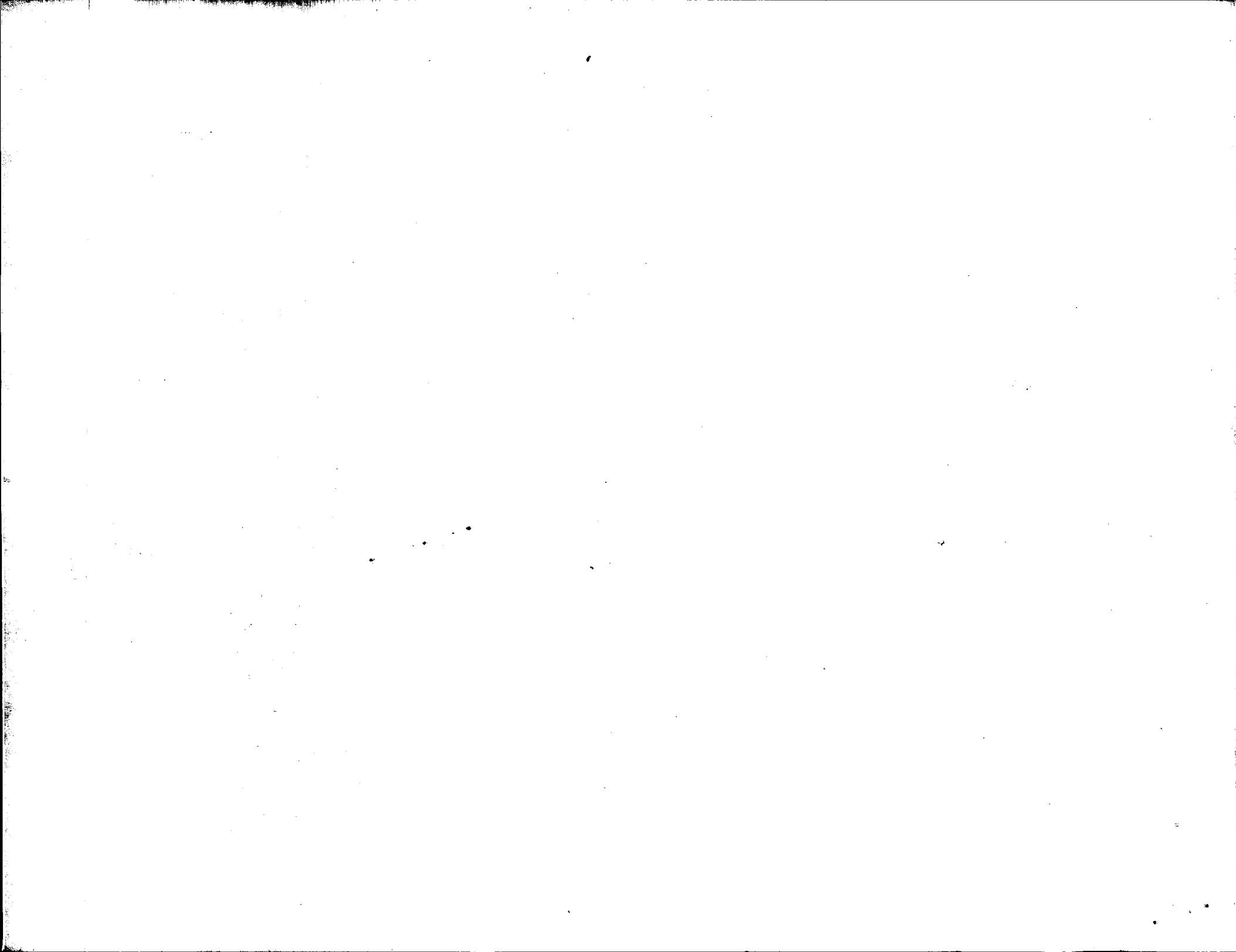
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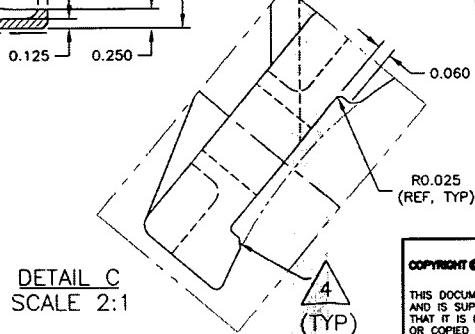
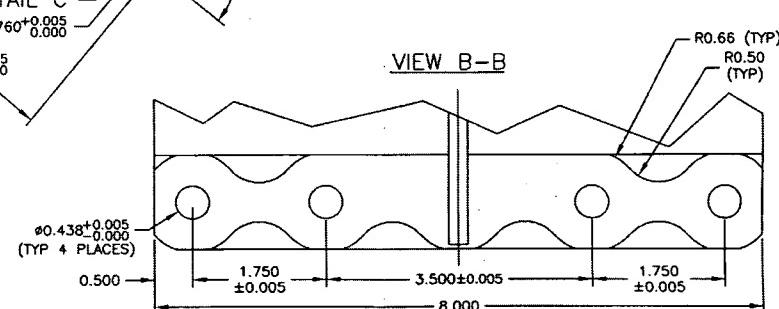
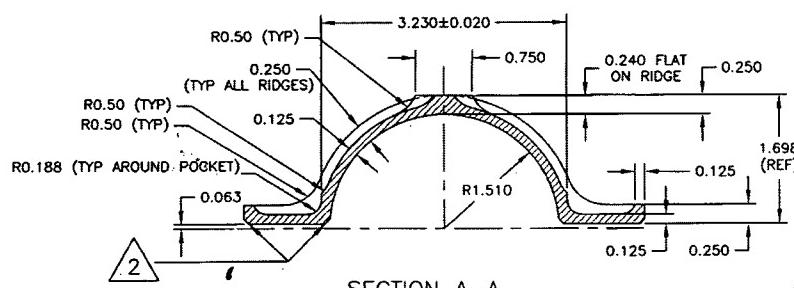
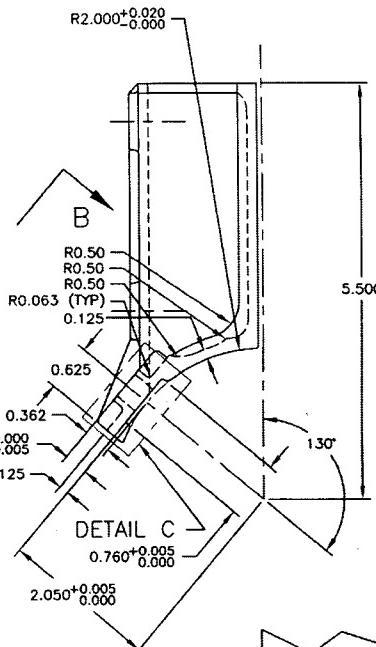
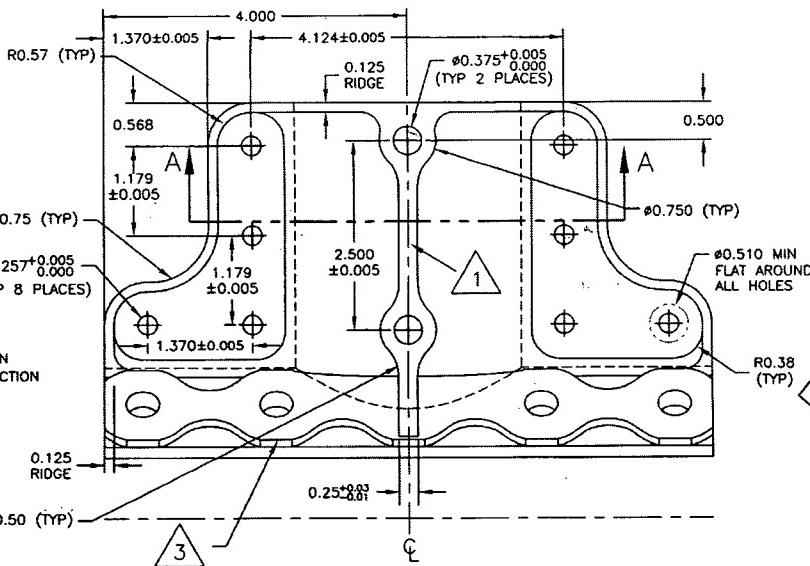
Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge		By	Date
A	0.438	0.443	DT8682	.4410	.4416	.4410
B	1.745	1.755		1.750	1.750	1.750
C	3.495	3.505		3.500	3.500	3.500
D	1.745	1.755		1.750	1.750	1.750
E	7.990	8.010		8.005	8.005	8.005
F	0.490	0.510		.505	.505	.505
G	0.257	0.262	DT8683	.258	.258	.258
H	0.375	0.380	DT8684	.377	.376	.376
I	0.490	0.510		.503	.503	.503
J	1.174	1.184		1.180	1.179	1.179
K	0.558	0.578		.571	.571	.571
L	1.174	1.184		1.180	1.179	1.179
M	1.365	1.375		1.370	1.370	1.370
N	2.495	2.505		2.500	2.500	2.500
O	4.119	4.129		4.124	4.124	4.124
P	0.115	0.135		.127	.125	.125
Q	0.115	0.135		.132	.132	.132
R	0.240	0.260		.251	.250	.250
S	0.115	0.135		.132	.132	.132
T	0.178	0.198		.188	.188	.188
U	3.210	3.250		3.228	3.232	3.232
V	0.230	0.250		.237	.237	.237
W	0.115	0.135		.130	.130	.130
X	0.307	0.312		.311	.311	.311
Y	0.760	0.765		.764	.764	.764
Z	0.352	0.372		.365	.365	.365
AA	0.470	0.530		.500	.500	.500
AB	0.615	0.635		.628	.628	.628
AC	0.053	0.073		.063	.063	.063
AD	0.240	0.260		.250	.252	.252
AE	1.500	1.520		1.509	1.509	1.509
AF	0.115	0.135		.135	.135	.135
AG	0.240	0.280		.256	.270	.270
AH	0.240	0.260		.251	.251	.251
AI	2.000	2.020		.2010	.2010	.2010
AJ	0.023	0.043		.033	.033	.033

Accept/Reject

Measured by:	<i>JK</i>	Audited by:	<i>JKL</i>
Date:	07/10/07	Date:	07/10/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JKL</i>	<i>JKL</i>





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OR COPIED OR COMMUNICATED TO ANY OTHER  
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DART AEROSPACE LTD.

**RELEASED**

05.12.06

### NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063° x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

E

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 3475  
ENGINEERING RETURN TO SHOP COPY

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAMILTON, ONTARIO, CANADA
DS	PH	REV. E
CHECKED	APPROVED	DRAWING NO. D2574
DATE		SHEET 1 OF 1 SCALE 2:1

DATE 05.07.13 TITLE INNER AFT SADDLE